



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

5173171
649.5010E

Job Sheet 187497



Part No: 649.5010E

Job Qty: 240 ft

Part Name: Deflector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/5/18

Job Tracking No:

Due Date: 4/10/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV D

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft	240 ft	4/10/19		0.00	0.00	Purchasing - 1		At 19/04/17
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	240 pcs	4/10/19		0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		

					B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	At 19/04/17
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	240 pcs	4/10/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9.89
130	Packaging 3-1 - Stock - B4B	240 pcs	4/10/19	0.00 0.00	Packaging 3 - 1 - B4B	DM
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Plex 4/16/19 3:35 PM Dart.Hadley.Shannon	

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B					
140 QC 21 - SA FT	240 ft	4/10/19	0.00 0.00	QC 21 - SA - 21	APR 17 2019 DAS 70 9-89
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - Issue P/O: _____ a)Description: EXTRUSION FOR DEFLECTOR e) Material: 7075-T6 f)Material Descriptions: certification required 110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material certification is attached 120 - (QC6- All purchased or subcontracted products) Ensure Material certification comply to Dwg 649.5000 130 - (Identify as per dwg & Stock Location: _____) LOCATION: MAT036 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
649.5010P	Deflector	240 ft (1 ea)	100-Purchasing - Ft	S173016	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Purchasing - Ft	649.5010P	240	240	240	
Allocated Container Detail					
	Qty	Container No	Location	Init	
	240	S173016	purchasing	_____	
Part Specifications					
Specifications could not be found.					



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649.5010E
Job Sheet 187497



Part No: 649.5010E

Job Qty: 240 ft

Part Name: Deflector



Part Weight: 0 lbs

Status: New

Priority: Medium

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Description:

Note: DWG REV D

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft	240 ft		4/10/19	0.00	0.00	Purchasing		
110	Packaging	240 pcs		4/10/19	0.00	0.00	Packaging2		
120	QC	240 pcs		4/10/19	0.00	0.00	QC6		
130	Packaging	240 pcs		4/10/19	0.00	0.00	Packaging3-1		
140	QC21-SA FT	240 ft		4/10/19	0.00	0.00	QC21		

Part Op 100 - Issue P/O: 41970 a) Description: EXTRUSION FOR DEFLECTOR e) Material: 7075-T6 f) Material Descriptions: certification required

110 - Ensure material certification is attached

120 - Ensure Material certification comply to Dwg 649.5000

130 - LOCATION: MAT036

CL

DEC 06 2018

1240ft

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
649.5010P	Deflector	240 ft (1 ea)	100-Purchasing - Ft	<i>5173016</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	649.5010P	240	0	0

Part Specifications

Specifications could not be found.

Plex 12/6/18 8:03 AM dart.lavoie.chantal

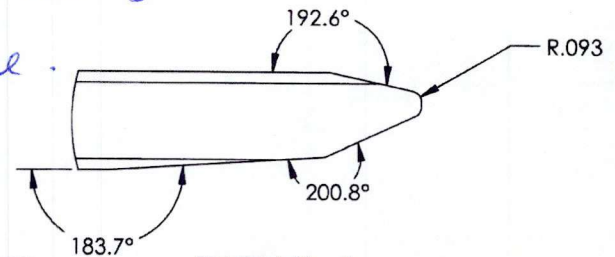
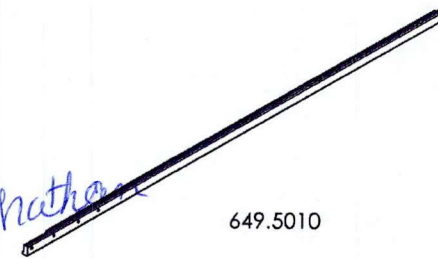
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NOTES: UNLESS OTHERWISE SPECIFIED

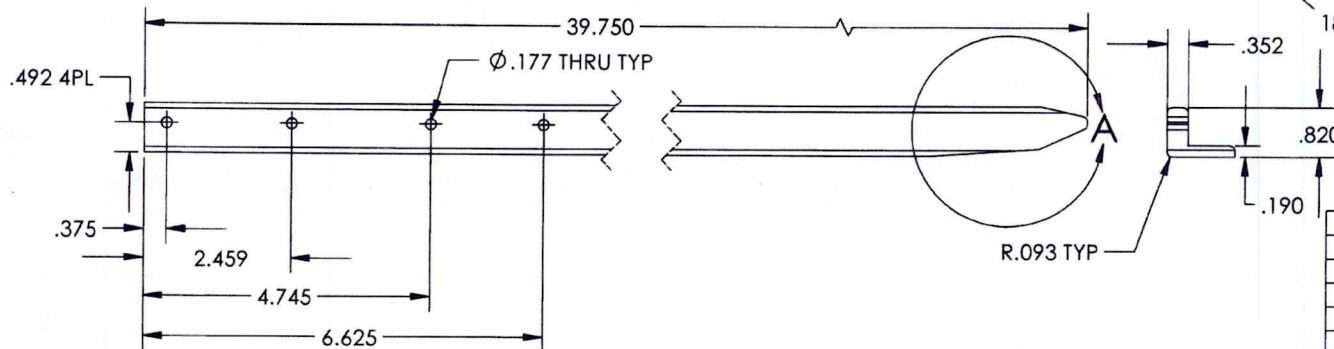
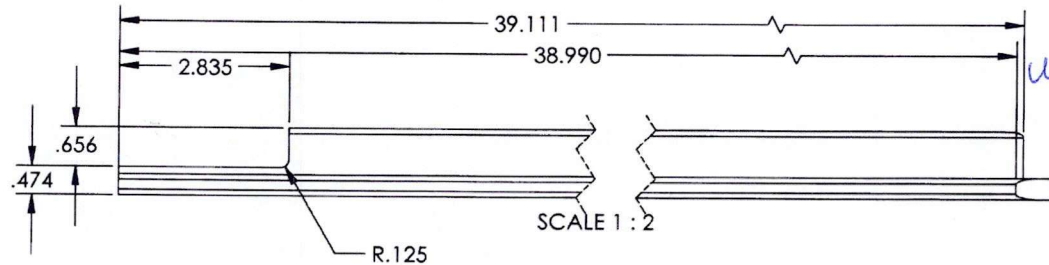
1. PRIMARY MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.
ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.
2. FINISH: ANODIZE IAW MPP-172 SECTION 2.1;
PRETREAT IAW MPP-172 SECTION 3.1;
PRIME IAW MPP-172 SECTION 4.2; 1-2 MIL MAX.
3. DE BURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION, 12 PT. CENTURY GOTHIC.
5. ALL DIMENSIONS SHOWN PRIOR TO FINISH.
6. PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5010 DEFLECTOR.SLDPRT, LAST MODIFIED 04-16-12.
7. PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5012 DEFLECTOR.SLDPRT, LAST MODIFIED 11-03-11.
8. PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5013 DEFLECTOR.SLDPRT, LAST MODIFIED 04-16-12.
9. PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5014 DEFLECTOR.SLDPRT, LAST MODIFIED 04-04-17.

E-MAILED
NOV 21 2018

*Quote sent
Kaiser alum. Nathan
universal alloy.
Anne.*



DETAIL A
SCALE 1:1



QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
	5	649.5014	DEFLECTOR	△	△△
	4	649.5013	DEFLECTOR	△	△△
	3	649.5012	DEFLECTOR	△	△△
	2	649.5011	DEFLECTOR	△	△
	1	649.5010	DEFLECTOR	△	△△
PARTS LIST					
NEXT ASSY (S)			ORIGINAL DATE		
649.4700			11-03-11		
			DRAWN BY		
			A. GUAN		
			CHECKED BY		
			P. BRAVO		
			DRAWING APPROVAL		
			11-03-11		
			CONTRACT NO.		
			UNLESS OTHERWISE SPECIFIED		
			DIMENSIONS ARE IN INCHES		
			TOLERANCES ARE:		
			2 PLACE DECIMALS ±.03		
			3 PLACE DECIMALS ±.010		
			ANGLES ±.5°		
			SCALE NONE		
			SHEET 1 OF 5		

DART 3030 ENTERPRISE CT., SUITE A
VISTA, CA. 92081
(760)-724-5300

DEFLECTOR
SIZE B CAGE CODE 07M26 DWG. NO. 649.5000 REV. D

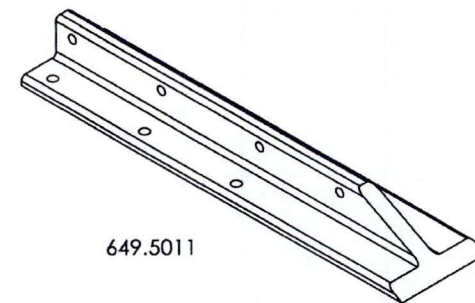
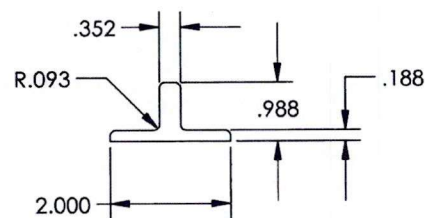
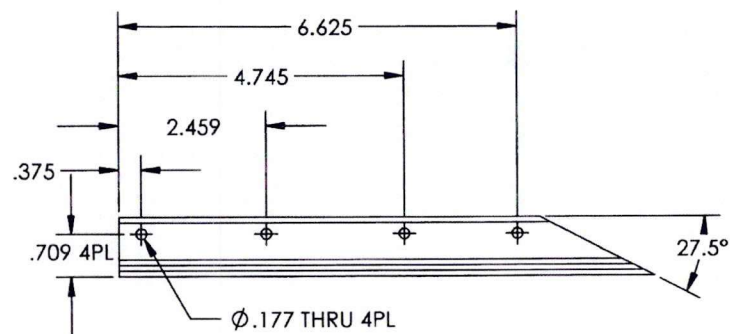
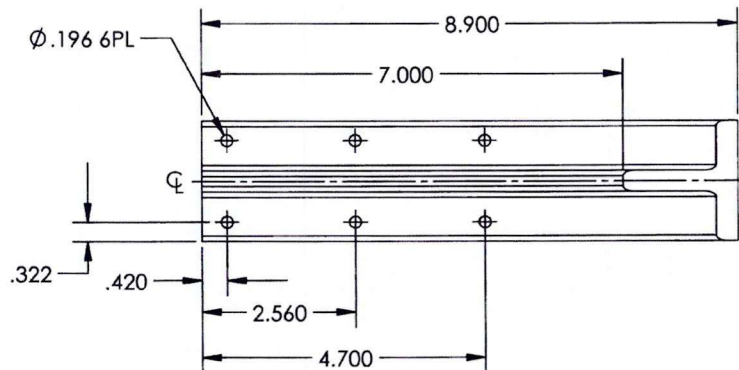
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A

B

C

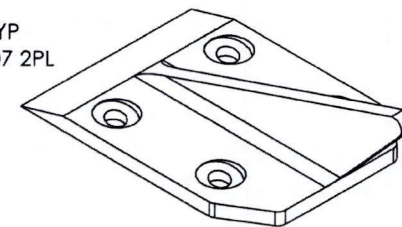
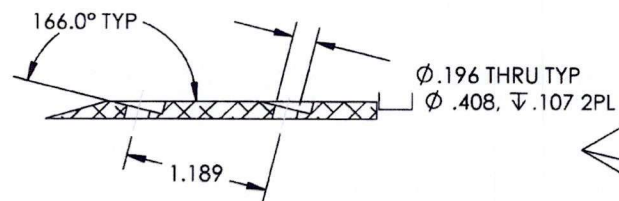
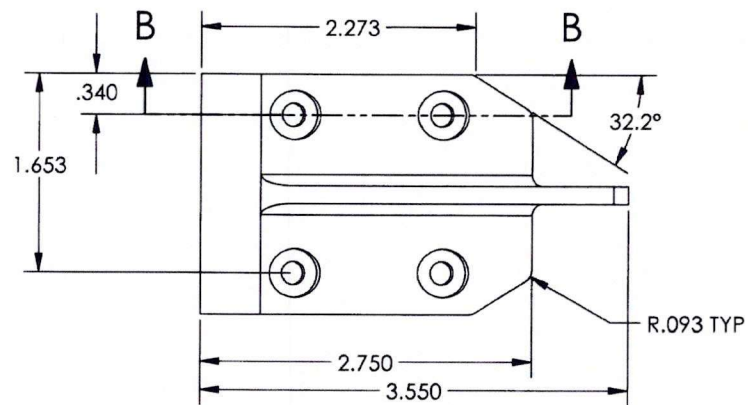
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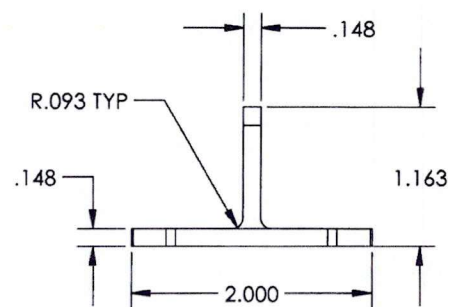
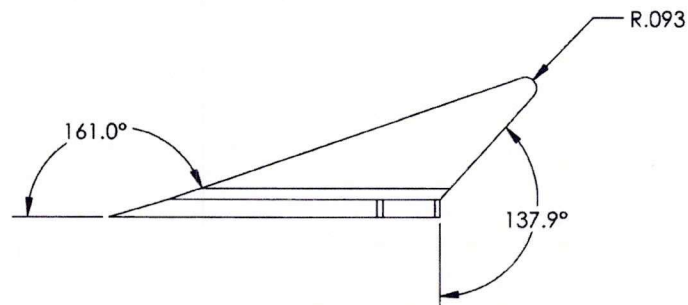
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ORIGINAL DATE 11-03-11		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY A. QUAN	CHECKER P. BRAYO	APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAYO		DEFLECTOR	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SHEET B 07M26	REV D
DWG. NO. 649.5000		SHEET 2 OF 5	

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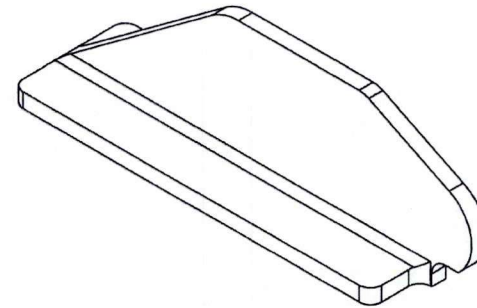
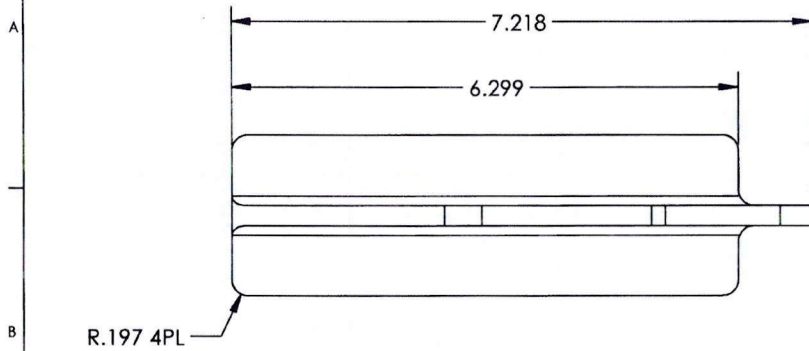


649.5012

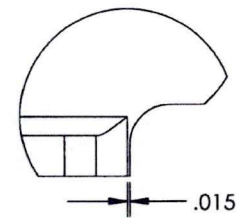
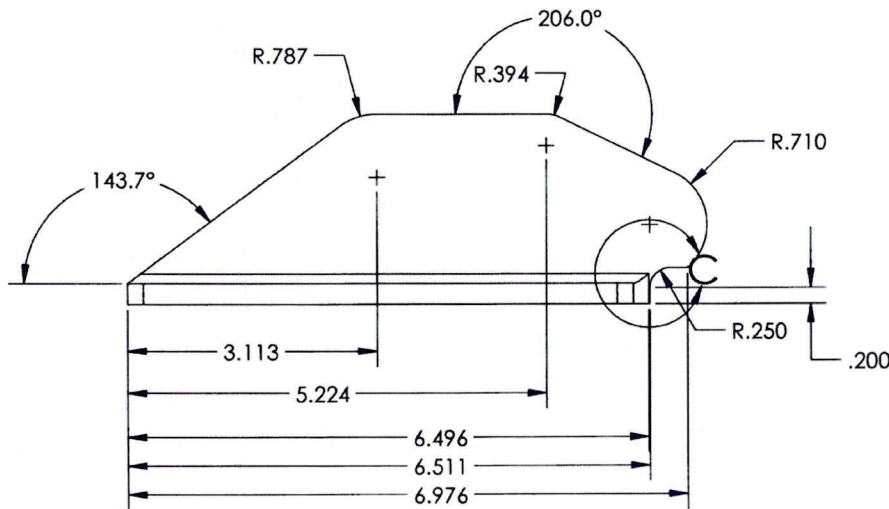


ORIGINAL DATE MO-DA-YR 11-08-11		 DART AEROSPACE 3030 ENTERPRISE CT. SUITE A VISTA, CA. 92081 (760)-724-5300 APICAL INDUSTRIES INC. DBA DART AEROSPACE	
DRAWN BY A. GUAN	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO	DATE 11-08-11		
CONTRACT NO.			
DEFLECTOR			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 649.5000	REV. D
SCALE NONE		SHEET 3 OF 5	

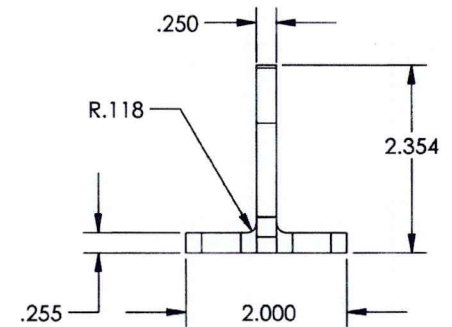
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649.5013

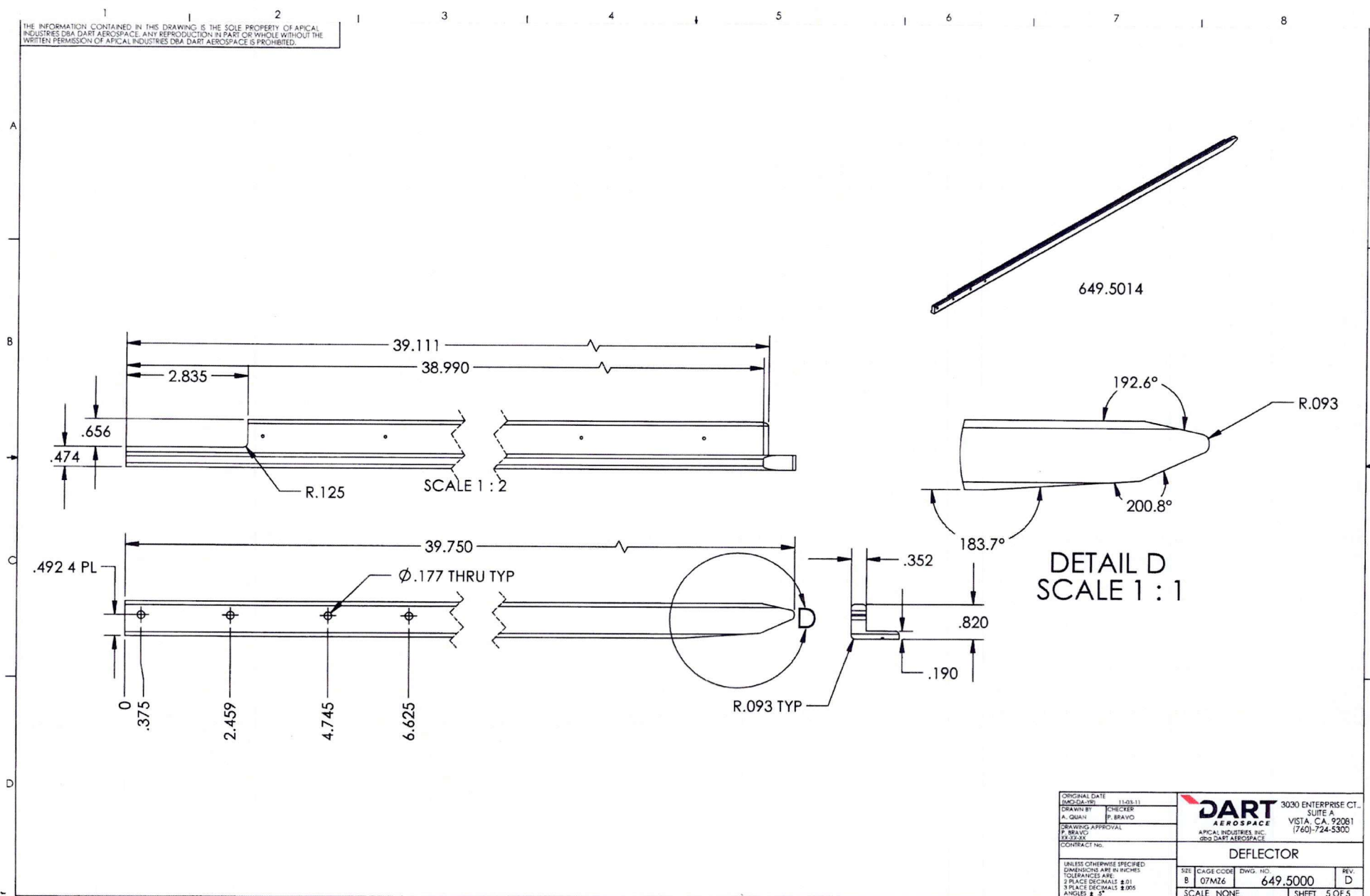


DETAIL C
SCALE 2 : 1.5



ORIGINAL DATE (MM-DD-YY)		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY A. QUAN	CHECKED BY P. BRAVO	DART AEROSPACE APICAL INDUSTRIES, INC. DRA DART AEROSPACE	
DRAWING APPROVAL P. BRAVO		DEFLECTOR	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS: ± .01 3 PLACE DECIMALS: ± .005 ANGLES: ± 5°		SHEET B	REV D
CAGE CODE 07M26		DWG. NO. 649.5000	SHEET 4 OF 5
SCALE: NONE			

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041970**

Supplier: KAI001-VU
Kaiser Aluminum
6573 W WILLIS ROAD
CHANDLER, AR 85226 USA
Phone: 520 796 1097
Fax: 520 796 0596

PO No: PO041970

PO Date: 12/6/18

Due Date: 4/10/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
DEC 06 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments: QUOTE NO. 29654

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	187497	649.5010P			Deflector : AS PER DWG 649.5010 REV. D MAT'L: 7075-T651 PER AMS-QQ-A-250/12 OR 7075-T7611 PER AMS- QQ-A-200/11 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,NICKS,OR DENTS	Firmed	-	4/10/19	240 ft	0 ft	240 ft	\$3.69/ft	\$885.60
Grand Total:													\$885.60

DAS
70
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO041970

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, appearing to be "CL" or similar, with a large, stylized flourish underneath.

Plex 12/6/18 8:13 AM dart.lavoie.chantal



6520 W. Allison Rd.
Chandler, AZ 85226
866-525-3926

INVOICE #
1502 - 256150

Sold To: 12195808

Dart Aerospace LTD
1270 Aberdeen St

Ship To: 12195808

Dart Aerospace LTD
1270 Aberdeen St

Hawkesbury

ON K6A 1K7

Hawkesbury

ON K6A 1K7

Date of Invoice 04/05/19	Customer Order Number PO041970			Mill Lot # 193917
Standard Terms Net 30 Days	Incoterms Destination	Ecode	Press 8	

Item #	ITEM DESCRIPTION OF EXTRUDED ALUMINUM PROFILE		QUANTITY SHIPPED	PRICE/USD	TOTAL
1	ORIGINAL INVOICE				
	Alloy: 7075	Temper: T6511	126 Lbs		
	Specification: AMS QQ-A-200/11A		240.00 Feet	\$3.69 /Ft.	\$885.60
	Finished Length (in.): 144.000	Die #: 29430	20 Pcs		
CERTIFICATION REQUIRED					
Customer Stencil 649.5010					
Profile # 649.5010					
Packing List #: 13163			Total Gross Lbs: 140		
Packaging Fiber Box			Num. of Boxes: 1		
NLR EIN: 56-2553181					
ECCN EAR99 Schedule B: 7604.29.1000					

ACH:

JPMorgan Chase Bank, NA
Swift Code: CHASUS33
Routing #: 021000021
Account Name: Kaiser Aluminum Fabricated Products, LLC
Account #: 304609064

SET-UP CHARGE	\$0.00
TOOLING CHARGE	\$0.00
EXACT PC COUNT	\$0.00
MISC. CHARGE	\$0.00
WEIGHT SURCHARGE	\$0.00

Manufactured in the United States of America. These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. government or as otherwise authorized by U.S. law and regulations. All currency in US dollars.

Total Amount Due: \$885.60USD

CERTIFIED TEST REPORTDart Aerospace LTD
1270 Aberdeen StMill Lot #: **193917**

Hawkesbury

ON K6A 1K7

Invoice #: **256150**

Customer Order #: PO041970	Shipment Complete		
Produced To : 649.5010	Packaging Fiber Box		Date : 04/05/19

Item Number: **1** Die Number: **29430** Net Weight (Lbs.): **126**
Alloy - Temper: **7075 - T6511** Cut Length (in.): **144.000** No. of Boxes: **1**
Specifications: **AMS QQ-A-200/11A** No. of Pieces: **20**
Customer Stencil: **649.5010** Feet: **240.00**

Remarks:

Mechanical Test Reports			YS	UTS		Conductivity	
Mill Lot #	# Pcs.	Alloy - Temper	(ksi)	(ksi)	% Elong.	(%IACS)	SCF
193917-1	20	7075-T6511	80.9	87.5	11.8	31.5	

Actual Chemistry

Heat	Alloy	%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Zn	%V	%Ti	%Zr
F18-42823	7075	0.09	0.16	1.59	0.02	2.5	0.193	5.86	0.011	0.032	0.012

Chemical Composition Limits

Alloy	SI Min	FE Min	CU Min	MN Min	MG Min	CR Min	ZN Min	TI Min	ZR Min	V Min	Others Each
7075	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00			0.05
	SI Max	FE Max	CU Max	MN Max	MG Max	CR Max	ZN Max	TI Max	ZR Max	V Max	Others Total
Correct Cert	0.40	0.50	2.0	0.3	2.9	0.28	6.1	0.20			0.15
Remainder is Aluminum											

Certified Test Report: Kaiser Aluminum Alexco LLC, hereby certifies that metal shipped under this order was made in the USA from material melted in the USA and was inspected and tested and found to be in conformance with the applicable specifications forming a part of the description set forth in Kaiser Alexco's sales acknowledgement form. Any warranty is limited to that shown on Kaiser Alexco's general terms and conditions of sale. Test reports are on file subject to examination.

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Travis Schmidt: Technical Manager

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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 649.5010E

PO / BATCH NO.: P0041970/S173191

DATE: 19/04/17

MATERIAL CERT REC'D: Yes

THICKNESS ORDERED: 0.352"

QUANTITY RECEIVED: 240ct

THICKNESS RECEIVED: 0.352"

QUANTITY INSPECTED: 240ct

SHEET SIZE ORDERED: —

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	<u>Ans QQ-A-200/11</u>
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	<u>P0041970</u>
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>61</u> DATE: <u>APR 17 2019</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in